

Appl. No. (not yet known)
Preliminary Amendment dated March 25, 2004
Continuation Application of SN 09/869,532

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-47 (canceled)

Claim 48 (new): A method for manufacturing products with a coating, wherein from at least one mass comprising at least natural polymers, a base product is manufactured, having a first coating upon one relevant part thereof, and a second coating over at least a portion of said first coating, said first coating having a surface tension which is approximately equal to or preferably lower than the surface tension of a portion of the at least one portion of the base product.

Claim 49 (new): A method according to claim 48, wherein the base product is formed in a mold with raising of pressure and/or temperature, preferably by means of injection molding.

Claim 50 (new): A method according to claim 48, wherein the at least one mass is introduced in or through a mold and is heated in the mold, such that at least cross-linkage of the natural polymers occurs, while surface tension-reducing agents are incorporated in the mass.

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Claim 51 (new): A method according to claim 48, wherein the at least one mass is at least substantially manufactured as paper-forming mass.

Claim 52 (new): A method for manufacturing coated products, according to claim 48, wherein in the at least one mass, release agents are incorporated in an amount such that during heating, a portion of the release agents egresses from the mass and bonds to the wall of the mold, such that during manufacture of successive products in the same mold, a substantial constant layer of release agent always remains present.

Claim 53 (new): A method according to claim 48, wherein as release agent, a surface tension-reducing component is added to the mass.

Claim 54 (new): A method according to claim 48, wherein a coating is used having a surface tension of less than 42 dyne/cm (42×10^{-3} N/m), preferably less than 36 dyne/cm (36×10^{-3} N/m) and more in particular less than 32 dyne/cm (32×10^{-3} N/m).

Claim 55 (new): A method according to claim 48, wherein a product is formed which, after leaving the molding die in which it is formed, has a surface tension of less than 44 dyne/cm and greater than 30 dyne/cm, while a coating is applied to at least a portion of the surface, said coating being water based and having a surface tension of between 40 and 27 dyne/cm.

Claim 56 (new): A method according to claim 48, wherein the product, upon leaving the mold, has a moisture content of less than 3 wt.%, while by means of coating, moisture, in particular water, is introduced into the product.

Claim 57 (new): A method according to claim 48, wherein the product, upon leaving the mold, has a moisture content of less than 3 wt.%, while by means of coating, moisture, in particular water, is introduced into the product.

Claim 58 (new): A method according to claim 48, wherein as coating, a water based, one phase system is used, preferably having few micelles.

Claim 59 (new): A method according to claim 48, wherein the at least one coating is applied to the base product at a temperature of between 20°C and 50°C, preferably between 25°C and 50°C, the arrangement being such that the surface tension of the coating is slightly reduced with respect to the surface tension at lower temperatures.

Claim 60 (new): A method according to claim 48, wherein as coating, in particular as first coating, a coating is used comprising at least one component from the group consisting of melamine, acrylic binders, water-resistant lacquers, cellulose lacquers, cellulose acetate propionates, polyethylene, polyacrylates, synthetic polymers, natural polymers, synthetic waxes, natural waxes, polyactic acid, and combinations thereof.

Claim 61 (new): A method according to claim 48, wherein as coating, in particular as second coating, a coating is used

comprising at least one component from the group consisting of acrylic binders, latices, styrene-butadiene latex, polyvinyl alcohol, polyvinyl acetate, polyacrylates, polyethylene glycol, polyactic acid, synthetic polymers, natural polymers, natural waxes, synthetic waxes, for instance ionic polyethylene waxes, and combinations thereof.

Claim 62 (new): A method according to claim 48, wherein in the coating, in particular the first and/or second coating, cross linkers are incorporated.

Claim 63 (new): A method in accordance with claim 62, wherein the cross-linking agent is selected- from the group consisting of zirconium acetate, urea formaldehyde, melamine formaldehyde, glyoxal, ammonium zirconium carbonate, polyamideamine-epichlorohydrin, epoxides, trimetaphosphate and combinations thereof.

Claim 64 (new): A method according to claim 61, wherein in the at least one coating, at least one of the waxes is combined with at least one of the other components mentioned.

Claim 65 (new): A method according to claim 48, wherein at least one coating is used which increases the water vapor proofness of the product.

Claim 66 (new): A method according to claim 48, wherein at least as outer or outermost coating, and FDA-allowed coating is used.

Claim 67 (new): A method according to claim 59, wherein at least as outer or outermost coating, a fat-resistant and/or fat-tight coating is used.

Claim 68 (new): A method according to claim 48, wherein the at least one coating is applied to only one part of the product, the surface tension of the parts of the product that remain clear of the coating being kept or rendered lower than the surface tension of said coating.

Claim 69 (new): A method according to claim 48, wherein the product is manufactured from at least two different masses, the surface tensions of the parts formed from the different masses preferably differing from one another.

Claim 70 (new): A method according to claim 48, wherein the at least one coating is applied by spraying.

Claim 71 (new): A method according to claim 48, wherein the at least one coating is applied by atomizing.

Claim 72 (new): A method according to claim 70, wherein the at least one coating is applied by airless spraying or atomizing.

Claim 73 (new): A method according to claim 70, wherein the at least one coating is applied by spraying or atomizing with compressed air-control.

Claim 74 (new): A method according to claim 48, wherein the product has at least one receiving cavity, the receiving cavity being at least partially filled with fluid coating

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and subsequently poured empty, such that a film of coating remains behind on at least a portion of the wall of the receiving cavity.

Claim 75 (new): A method according to claim 48, wherein on or in at least a part of the base product there is provided an agent influencing the properties of the relevant product part, prior to the application of the at least one coating to the relevant product part.

Claim 76 (new): A method according to claim 75, wherein as said influencing agent, a softener or softener-containing agent is used.

Claim 77 (new): A method according to claim 75, wherein as said influencing agent, water or a water-containing agent is used.

Claim 78 (new): A method according to claim 48, wherein a coating is used comprising an agent influencing the properties of the base product, in the form of at least a softener.

Claim 79 (new): A method according to claim 78, wherein as softener, water is used.

Claim 80 (new): A method according to claim 78, wherein to the relevant base product part, at least one coating is applied which is denser than said agent influencing the properties of the base product.

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Claim 81 (new): A method according to claim 48, wherein a coating is used in which a surface tension-reducing agent is included which provides for a reduction of the surface tension of the coating layer after drying.

Claim 82 (new): A method according to claim 81, wherein as surface tension-reducing agent, an oily or oil-containing product is used.

Claim 83 (new): A method according to claim 81, wherein as surface tension-reducing agent, silicone oil is used.

Claim 84 (new): A method according to claim 83, wherein between 0.5 and 15% of silicone oil based upon the total volume of coating composition together with silicone oil is employed.

Claim 85 (new): A method according to claim 84, wherein between 2 and 10% of silicone oil based upon the total volume of coating composition together with silicone oil is employed.